

# Work Order ID 78708

**\*78708\***

Page 1

January-13-12 7:06:35 AM

Item ID: D412-694-04

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Door Assembly

Start Date: 12/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/13

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D412-694	Rev C1

100 0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Issue red decal labels for D412-694-04. CHG005

110

0.00

**\*110\***

COMPOSITE ASSEMBLY

Small Fab

Memo

0.00

Small Fab

D412-694-04 Drill Process

1- Drill pilot holes Ø(#30) using Dwg Tool D3140-303A for the doublers. Drill  
(2) holes in two places Ø3/16" (0.188) for the slot opening. Router slot using  
D3144-T11/-T12 as per Dwg D412-694 page 3. Note: Ensure slot is aligned

14.09.01

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Start Date: 12/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop **\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

DAS  
38  
9-89

14-10-16

130

COMPOSITE ASSEMBLY

0.00

**\*130\***

Small Fab

Memo

0.00

Small Fab

1- Install inserts as per Dwg D412-694 page 3 & 5 (section AA-AA) and page 4 (view MM-MM).  
2- Sand flush excess Hysol around the insert on both doors.

14-09-01

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control

Inspect that inserts are flush with the surface.

DAS  
38  
9-89

14-10-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D412-694-04

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Door Assembly

Start Date: 12/01/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

0.00

\*150\*

Small Fab

COMPOSITE ASSEMBLY

Memo

0.00

Small Fab

1. Apply primer filler and reducer around the inserts on both doors.

A/R 11045 Primer Filler Batch: 130555

A/R 12375S Reducer Batch: 180555

18

CH4.09.15

160

QC14- Inspect Spray Paint

0.00

\*160\*

QC

Memo

0.00

Quality Control

2 14-09-15

170

0.00

\*170\*

Small Fab

COMPOSITE ASSEMBLY

Memo

0.00

Small Fab

D412-694-04 Assembly Process

1- Install top/bottom of the door, D3112-1 Guard, D3130-1 Clevis Base and D3131-1 Stop (top only) as per Dwg D412-694 page 5 (section AA-AA & FF-FF).

2- Install D3111-041 Plate Assembly. If needed, install

2 14.09.30

(Pto) →

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
14-09-03	170	For section AA-AA replace AN760508LL with AN960508LL (8LL doesn't exist)	ET	14-09-03	2 Last only	A.P. 14.09.03	5 14/10/23	
14-09-04	170	For <del>MS21042608</del> MS25281-R6 clamps use MS2104263 nut instead of MS21042608. MS21042608 nut is for a 5/32" bolt MS2104263 is for a 3/16 bolt. MS24694-553 screw is 3/16" (2 PL)	ET	14-09-04		A.P. 14.09.03		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: Drill holes NCR: Yes No DQA: JA Date: 14/12/13  
 Resolution: Rework Disposition: Machined parts QA: N/C Closed: 8/10/21 Date: 14/12/10

NCR: <u>14-4433</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
14-09-04	120	drilled hole for clevis base in wrong location	A.P. 14.09.04	drill hole in proper location chamfer edges of wrong hole on both sides fill with Hysol EA934 + milled fiber	A.P. ET 14-09-03	6 14/10/23	2/10/23	5 14/10/23

NOTE: Date & initial all entries

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Item ID: D412-694-04 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Door Assembly  
 Start Date: 12/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 26/01/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180	QC5- Inspect part completeness to step on W/O	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control	Install door on mock up helicopter to insure proper fit and function.								

190	Small Fab	0.00							
<b>*190*</b>									
Small Fab	Memo	0.00							
Small Fab	(Put red label inside before putting the cover D3119-042/or Vip trim)								

install VEP from 14-10-16  
 DAS 38 9-89 14-10-16

200	Identify as per dwg & Stock Location: _____	0.00							
-----	---	------	--	--	--	--	--	--	--

<b>*200*</b>									
Packaging	Memo	0.00							
Packaging									

14-10-15

(P40) →

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
14-10-20	190	install uip <del>to</del> trim using NAS391-B6P washer B124605 x10 NAS388-6-8P screw B129384 x10 ALS4-632-80 B112495 x10	BT	14-10-20					

Part No: D412-694-04 PAR #: \_\_\_\_\_ Instructions  
 Fault Category: Incomplete/unclear NCR: Yes No DQA: BT Date: 14/12/11  
 Resolution: rework ~~use as is~~ Disposition: Small fab QA: N/C Closed: BT Date: 14/12/10

NCR: <u>14-4434</u>		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
14-10-22	190	no documents supporting installation of UIP trim R.C. Poor contractors	A.P. 14.10.22	trim + install UIP trim to be as aesthetically pleasing as possible using above mentioned hardware	BT 14-10-22	S 14/10/23	NAS	S 14/10/23	

NOTE: Date & initial all entries



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Revision ID:

Stop **\*NS2\***

Item Name: Door Assembly

Start Date: 12/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

Memo

0.00

Quality Control

MLJ 14-10-27

u 14.10.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 78708

\*78708\*

Parent Item: D412-694-04

\*D412-694-04\*

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev: A 05.12.09 New Issue KJ/RF  
 IPP Rev: B 06.04.18 New dwg rev. ecn781 EC  
 IPP Rev: C 06.07.10 Revised per B24659 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS43DD3-40		Purchased	No			110	Each	36.0000	2	2			
										**		DAS 33 9-89	

\*NAS43DD3-40\*  
 Spacer

Location	Loc Qty	Loc Code
ST278	36	
110153	1	
112314	5	
112933	30	

80-005-2-8

Purchased No

170 Each 60.0000 21 21

\*80-005-2-8\*  
 Insert

\*\*

M120273

13-12-18

Location	Loc Qty	Loc Code
ST379	60	
113109	60	

ALS4-632-80

Purchased No

170 Each 172.0000 10 10

\*ALS4-632-80\*  
 Insert

\*\*

DAS  
33  
9-89

13-12-20

Location	Loc Qty	Loc Code
ST282	172	
112495	172	

112495

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D412-694-04

\*D412-694-04\*

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN525-10R7

Purchased

No

170

Each

225.0000

4

4

DAS

\*AN525-10R7\*

Screw

\*\*

127447

33  
9-89

Location

Loc Qty

Loc Code

ST345

225

115371

25

116737

100

118686

100

AN960JD10

NAS1149D0363J

Purchased

No

170

Each

0.0000

8

8

DAS

\*AN960.ID10\*

Washer

\*\*

126319

33  
9-89

AN960JD10L

NAS1149D0332J

Purchased

No

170

Each

0.0000

13

13

DAS

\*AN960.ID10I \*

Washer

\*\*

127431

33  
9-89

AN960JD10LL

Purchased

No

170

Each

3,641.000

29

29

DAS

\*AN960.ID10I I \*

Washer

\*\*

33  
9-89

Location

Loc Qty

Loc Code

ST337A

3641

19085

400

19600

3241

19600

AN960JD6L

Purchased

No

170

Each

758.0000

4

4

\*\*

\*AN960.ID6I \*

Washer

Location

Loc Qty

Loc Code

ST337A

758

5519

758

5519

DAS

33  
9-89

AN960JD8

NAS1149DN832

Purchased

No

170

Each

0.0000

2

2

DAS

\*AN960.ID8\*

Washer

\*\*

126319

33  
9-89

13-12-20

January-13-12 7:06:39 AM

Shop Packet Print

Page 2

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*78708\*

Parent Item: D412-694-04

\*D412-694-04\*

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD8L NAS1149DN816 Purchased

No

170

Each

415.0000

2

2

\*AN960JD8L\*

Washer

\*\*

DAS

33

9-89

122627

Location

Loc Qty

Loc Code

ST337A

415

6956

415

BSP45

Purchased

No

170

Each

177.0000

34

34

\*RSP45\*

Commercial Rivet

\*\*

DAS

33

9-89

23+120417

Location

Loc Qty

Loc Code

ST284

177

118614

177

BSP46

Purchased

No

170

Each

306.0000

12

12

\*RSP46\*

Commercial rivet

\*\*

DAS

33

9-89

11+119614

Location

Loc Qty

Loc Code

ST284

306

101237

6

112540

300

D3110-1

Manufactured

No

170

Each

8.0000

1

1

\*D3110-1\*

Escutcheon

\*\*

DAS

33

9-89

DAS

33

9-89

1.3-12-20

112540

Location

Loc Qty

Loc Code

ST026

8

52448

8

52448

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3110-3

Manufactured No

170 Each

1.0000

1

1

DAS

\*D3110-3\*

\*\*

102054

33

Handle

9-89

Location

Loc Qty

Loc Code

ST026

1

60661

1

D3111-041

Manufactured No

170 Each

119.0000

1

1

\*D3111-041\*

\*\*

Plate Assembly

Location

Loc Qty

Loc Code

Mezz

119

1053617

119

D3112-1

Manufactured No

170 Each

4.0000

2

2

DAS

\*D3112-1\*

\*\*

86777

33

Guide

9-89

Location

Loc Qty

Loc Code

ST026

4

59450

4

D3113-1

Manufactured No

170 Each

10.0000

1

1

\*D3113-1\*

\*\*

Spring

DAS

33

9-89

Location

Loc Qty

Loc Code

ST026

10

36725

10

36725

D3114-1

Manufactured No

170 Each

9.0000

1

1

\*D3114-1\*

\*\*

Pivot

Location

Loc Qty

Loc Code

GA

9

36726

9

X1

14 08 25

13-12-20

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W/O:		WORK ORDER CHANGES					
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Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3116-11

Manufactured No

170 f

70.0000 1.5 1.5

\*D3116-11\*

Seal

\*\*

14 - 09 - 10

Location

Loc Qty

Loc Code

ST408

70

27241

62

57494

8

x 1.5

D3116-5

Manufactured No

170 f

141.6000 5.67 5.67

\*D3116-5\*

Seal

\*\*

14 - 09 - 10

Location

Loc Qty

Loc Code

ST414

141.6

23699

12

27208

129.6

x 6.0

D3119-042

Manufactured No

170 Each

2.0000 1 1

\*D3119-042\*

Cover Assembly

\*\*

84377

DAS

33

9-89

Location

Loc Qty

Loc Code

ST164

2

60663

2

D3120-2

Manufactured No

170 Each

3.0000 1 1

\*D3120-2\*

Cover

\*\*

DAS

33

9-89

13-12-20

Location

Loc Qty

Loc Code

ST237

3

50344

3

50344

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3120-4

Manufactured No

170

Each

13.0000

1

1

\*D3120-4\*

Cover

\*\*

Location

Loc Qty

Loc Code

ST237

13

66220

13

66220

W for Russ

D3125-1

Manufactured No

170

Each

46.0000

1

1

\*D3125-1\*

Lever

\*\*

Location

Loc Qty

Loc Code

CA

46

1053617

46

X1

D3125-3

Manufactured No

170

Each

101.0000

1

1

\*D3125-3\*

Lever

\*\*

Location

Loc Qty

Loc Code

CA

101

1053617

101

X1

D3125-7

Manufactured No

170

Each

90.0000

1

1

\*D3125-7\*

Lever

\*\*

Location

Loc Qty

Loc Code

CA

90

1053617

90

X1

D3129-1

Manufactured No

170

Each

245.0000

2

2

\*D3129-1\*

Lever

\*\*

Location

Loc Qty

Loc Code

Mezz

245

1053617

245

X2

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78708

\*78708\*

Parent Item: D412-694-04

\*D412-694-04\*

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3130-1 Manufactured No

170 Each 297.0000 2 2

\*\*

17-08-26

\*D3130-1\*

Clevis Base

Location

Loc Qty

Loc Code

Mezz

297

1053617

297

x2

D3131-1 Manufactured No

170 Each 93.0000 1 1

\*\*

14-08-26

\*D3131-1\*

Stop

Location

Loc Qty

Loc Code

Mezz

93

1053617

93

x1

D3134-1 Manufactured No

170 Each 7.0000 1 1

\*\*

14-08-26

\*D3134-1\*

Rod

Location

Loc Qty

Loc Code

CA

7

52369

7

x1

D3134-4 Manufactured No

170 Each 5.0000 1 1

\*\*

14-08-26

\*D3134-4\*

Rod

Location

Loc Qty

Loc Code

CA

5

18376

1

50711

4

x1

D3140-08 Manufactured No

170 Each 0.0000 1 1

\*\*

B78943 131216

\*D3140-08\*

Door

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 78708

\*78708\*

Parent Item: D412-694-04

\*D412-694-04\*

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00


✓ D3143-1	Manufactured	No	170	Each	0.0000	1	1	
*D3143-1*			90203		**			ET 14-08-26
Clevis								

✓ D3143-3	Manufactured	No	170	Each	147.0000	3	3	
*D3143-3*			123614		**			ET 14-08-26
Clevis								

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			Mezz	147				
			1053617	147				
D3144-117	Manufactured	No		170	Each	1.0000	1	1
*D3144-117*				123816	**			ET 14-09-04
Doubler								

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			CA	1				
			22022	1				
D3144-119	Manufactured	No		170	Each	0.0000	1	1
*D3144-119*				110778	**			ET 14-09-04
Doubler								

D3144-121	Manufactured	No		170	Each	1.0000	1	1
*D3144-121*				123819	**			ET 14-09-04
Doubler								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			CA	1				
			22024	1				


 A3125-S      qty 1      Batch: 1053617      ET 14-09-03

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78708

\*78708\*

Parent Item: D412-694-04

\*D412-694-04\*

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3145-2

Manufactured No

170

Each

10.0000

1

1

\*D3145-2\*

Bracket

\*\*

## Location

## Loc Qty

## Loc Code

ST028

10

50097

8

50098

2

50097

D3146-2

Manufactured No

170

Each

7.0000

1

1

\*D3146-2\*

Bracket

\*\*

## Location

## Loc Qty

## Loc Code

ST028

7

50100

7

50100

D3147-1

Manufactured No

170

Each

1.0000

2

2

\*D3147-1\*

Pin

\*\*

86214

## Location

## Loc Qty

## Loc Code

ST028

1

59255

1

D3149-1RevB

Manufactured No

170

Each

0.0000

2

2

\*D3149-1RevB\*

Striker Plate

D3150-1

Manufactured No

170

Each

4.0000

2

2

\*D3150-1\*

Guide

\*\*

86214

13-12-20

## Location

## Loc Qty

## Loc Code

ST036

4

76199

4

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78708

\*78708\*

Parent Item: D412-694-04

\*D412-694-04\*

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3154-1 Manufactured No 170 Each 38.0000 1 1

\*D3154-1\*

Key

\*\*

14-08-26

## Location

## Loc Qty

## Loc Code

CA

38

1053617

38

X 1

D3157-1 Manufactured No 170 Each 300.0000 2 2

\*D3157-1\*

Spacer

\*\*

DAS

33

9-89

## Location

## Loc Qty

## Loc Code

ST030

300

1053617

300

1053617

D3159-041 Manufactured No 170 Each 34.0000 3 3

\*D3159-041\*

Bracket Assembly

\*\*

DAS

33

9-89

## Location

## Loc Qty

## Loc Code

ST030

34

50391

34

50391

D3159-044 Manufactured No 170 Each 29.0000 1 1

\*D3159-044\*

Bracket Assembly

\*\*

DAS

33

9-89

13-12-20

## Location

## Loc Qty

## Loc Code

ST030

29

24859

14

53088

15

24859

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78708

**\*78708\***

Parent Item: D412-694-04

**\*D412-694-04\***

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

FW10-032

Purchased

No

170

Each

268.0000

16

16

DAS

33

9-89

**\*FW10-032\***

Washer

\*\*

Location

Loc Qty

Loc Code

ST285

268

101203

210

19249

58

101203

FW4-032

Purchased

No

170

Each

97.0000

6

6

DAS

33

9-89

**\*FW4-032\***

Washer

\*\*

Location

Loc Qty

Loc Code

ST285

97

101203

97

101203

M7885/3-4-4

Purchased

No

170

Each

321.0000

2

2

DAS

33

9-89

**\*M7885/3-4-4\***

Rivets

\*\*

Location

Loc Qty

Loc Code

ST393

321

108077

321

108077

M7885/3-4-5

Purchased

No

170

Each

179.0000

1

1

DAS

33

9-89

**\*M7885/3-4-5\***

Rivet

\*\*

Location

Loc Qty

Loc Code

ST393

179

1108

179

1108

13-12-20

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 78708

\*78708\*

Parent Item: D412-694-04

\*D412-694-04\*

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS20392-1C11

Purchased

No

170

Each

69.0000

2

2

DAS

\*MS20392-1C11\*

Pin

\*\*

33  
9-89

## Location

## Loc Qty

## Loc Code

ST315

69

18822

69

18822

MS20392-2C11

Purchased

No

170

Each

55.0000

2

2

\*MS20392-2C11\*

Pin

\*\*

14-08-25

mezz

## Location

## Loc Qty

## Loc Code

Mezz

55

14149

55

MS20392-2C15

Purchased

No

170

Each

27.0000

7

7

\*MS20392-2C15\*

Pin

\*\*

124586

DAS  
33  
9-89

## Location

## Loc Qty

## Loc Code

ST316

27

101334

15

101340

12

MS21042L06

Purchased

No

170

Each

126.0000

2

2

\*MS21042L06\*

Nut

\*\*

126474

DAS  
33  
9-89

13-12-20

## Location

## Loc Qty

## Loc Code

ST300

126

118354

2

119109

100

119758

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78708

**\*78708\***

Parent Item: D412-694-04

**\*D412-694-04\***

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

170

Each

6,060.000

7

7

**\*MS21042L3\***

Nut

\*\*

126333

DAS

33

9-89

Location

Loc Qty

Loc Code

ST300

6060

117441

16

117885

32

118451

5

118927

3

119017

5530

119075

474

MS24665-151

Purchased

No

170

Each

351.0000

11

11

**\*MS24665-151\***

Cotter Pin

\*\*

125646

DAS

33

9-89

Location

Loc Qty

Loc Code

ST309

351

17566

351

MS24694-C4

Purchased

No

170

Each

267.0000

2

2

**\*MS24694-C4\***

SCREW

\*\*

DAS

33

9-89

Location

Loc Qty

Loc Code

ST289

267

15924

267

MS24694-S53

Purchased

No

170

Each

315.0000

2

2

**\*MS24694-S53\***

SCREW

\*\*

15924

DAS

33

9-89

1312-20

Location

Loc Qty

Loc Code

ST289A

315

113288

15

113359

300

113288

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78708

Parent Item: D412-694-04

Parent Item Name: Door Assembly

**\*78708\***

**\*D412-694-04\***

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS24694-S56

Purchased

No

170

Each

81.0000

4

4

\*\*

DAS

33

9-89

**\*MS24694-S56\***  
SCREW

~~127205~~  
125532

Location

Loc Qty

Loc Code

ST289A

81

104407

31

120142

50

MS24694-S60

Purchased

No

170

Each

90.0000

4

4

\*\*

DAS

33

9-89

**\*MS24694-S60\***  
Screw

Location

Loc Qty

Loc Code

ST289A

90

104407

90

104407

MS25281-R6

Purchased

No

170

Each

78.0000

2

2

\*\*

DAS

33

9-89

**\*MS25281-R6\***  
Clamp

Location

Loc Qty

Loc Code

ST290

78

19098

78

19098

MS27039-1-06

Purchased

No

170

Each

879.0000

12

12

\*\*

DAS

33

9-89

**\*MS27039-1-06\***  
Screw

Location

Loc Qty

Loc Code

ST291

879

104289

879

104289

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 78708

**\*78708\***

Parent Item: D412-694-04

**\*D412-694-04\***

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

170

Each

977.0000

6

6

DAS

**\*MS27039-1-08\***

Screw

\*\*

126319

33

9-89

Location

Loc Qty

Loc Code

ST291

977

117423

77

118910

26

119075

374

119109

500

MS35206-231

Purchased

No

170

Each

39.0000

2

2

DAS

**\*MS35206-231\***

Screw

\*\*

33

9-89

Location

Loc Qty

Loc Code

ST294

39

11735

39

11735

MS35650-305T

Purchased

No

170

Each

97.0000

4

4

DAS

**\*MS35650-305T\***

Nut

\*\*

33

9-89

Location

Loc Qty

Loc Code

ST296

97

11786

97

11786

MS51859-7

Purchased

No

170

Each

12.0000

3

3

DAS

**\*MS51859-7\***

Washer

\*\*

123482

33

9-89

13-12-20

Location

Loc Qty

Loc Code

ST296

12

111193

12

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 78708

\*78708\*

Parent Item: D412-694-04

\*D412-694-04\*

Parent Item Name: Door Assembly

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1169-10L

Purchased

No

170

Each

11.0000

4

4

\*NAS1169-10I \*

Washer

\*\*

DAS

33

9-89

Location

Loc Qty

Loc Code

ST276

11

11753

11

11753

NAS388-6-8P

Purchased

No

170

Each

133.0000

15

15

\*NAS388-6-8P\*

Screw

\*\*

DAS

33

9-89

Location

Loc Qty

Loc Code

ST278

133

116416

33

119673

50

119716

50

119673

14119716

NAS391B6P

Purchased

No

170

Each

178.0000

16

16

\*NAS391B6P\*

Washer

\*\*

DAS

33

9-89

13-12-20

Location

Loc Qty

Loc Code

ST278

178

116416

2

118840

76

118891

100

118891

**Dart Aerospace Ltd**

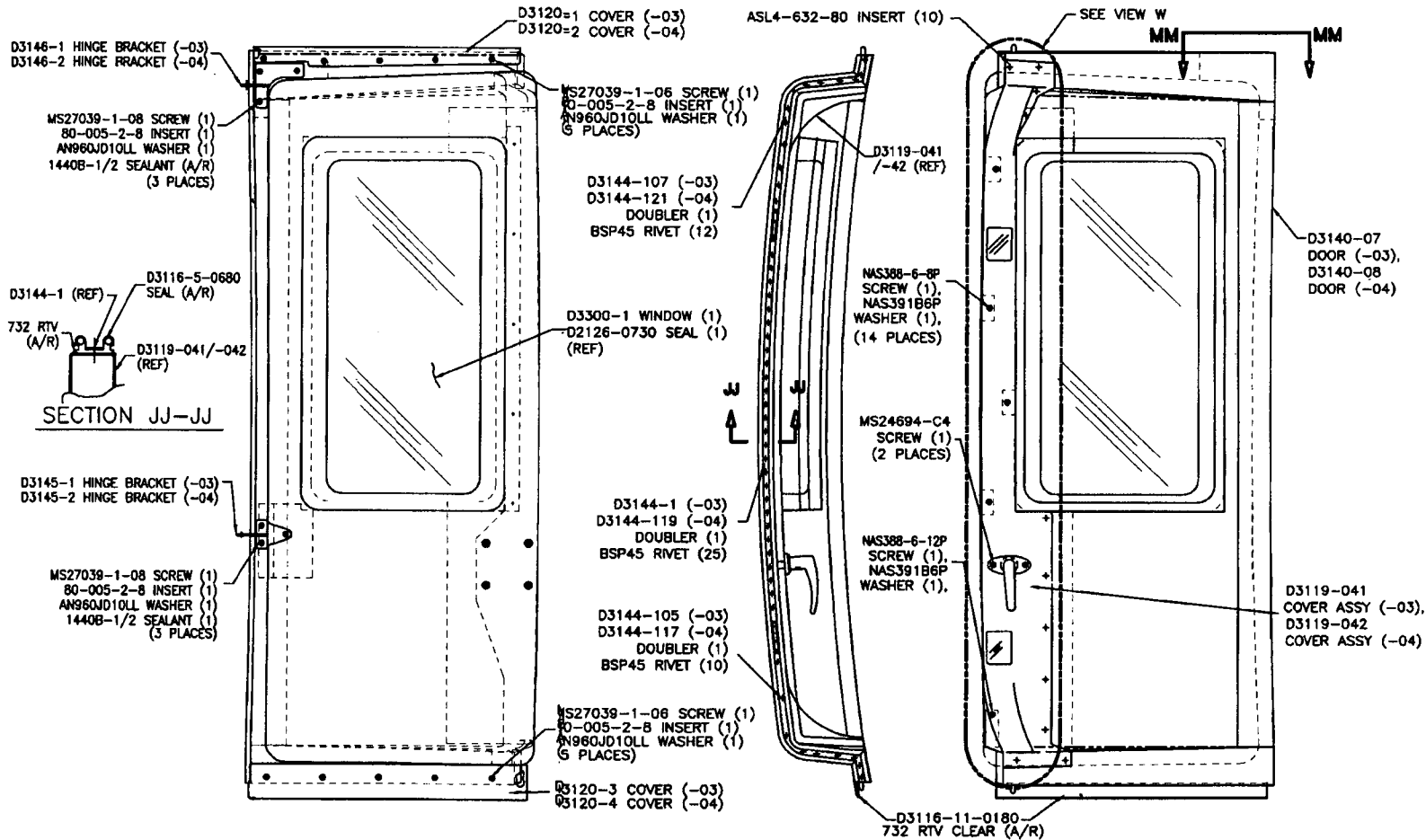
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D412-694-03 DOOR ASSY (SHOWN)**  
**D412-694-04 DOOR ASSY (OPP)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUPERSEDED

78708 M.C.U  
12/01/13

**FIGURE 5: Replacement Parts, D412-694-03/04 Door Assembly**

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Revision: **B**

Date: 04.10.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Métaux Castle / Castle Metals

80-005-2-3

insert

x 4

B 120273

D3119-042

cover assy

x 1

3120-2

cover

x 1

B50344

3120-4

cover

x 1

B66220

D3159-041

bracket assy

x 2

B50391

D3159-044

bracket assy

x 1

B24859

3145-2

bracket

x 1

B50098

Montréal: (514) 694-9575, (800) 806-6660, FAX (514) 695-3281

Toronto: (905) 858-3888, (800) 806-6660, FAX (905) 858-3883



# Métaux Castle / Castle Metals

~~D3157-1~~

~~stake plate~~

D3157-1

spacers

B1053617

x2

AN525-10R7

screw

B129706

x4

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